



European Patent
Office

EUROPEAN SEARCH REPORT

Application Number

EP 92 10 5935

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
A	GB-A-1 176 720 (DYNAMIT NOBEL AKTIENGESellschaft) 7 January 1970 * the whole document * ---	1	B24D3/14 C09K3/14 B24D3/16
A	GB-A-2 099 012 (KENNECOTT CORP.) 1 December 1982 * page 4, lines 38-48, 55-58 * ---	1	
A	EP-A-0 024 099 (MINNESOTA MINING AND MANUFACTURING COMPANY) 25 February 1981 * claims * ---	1	
A	US-A-4 325 710 (TANAKA ET AL.) 20 April 1982 * column 2, lines 33-55; column 3, lines 62-65 * ---	1	
A	DE-B-1 167 725 (WAKEFIELD CORP.) 9 April 1964 * column 3, line 60 - column 4, line 5 * ---	1	TECHNICAL FIELDS SEARCHED (Int. Cl.4)
A	GB-A-1 061 816 (THE CARBORUNDUM COMPANY) 15 March 1967 * page 1, line 60 - line 70 * ---	1	B24D C09K
A	TRANSACTIONS OF THE BRITISH CERAMIC SOCIETY vol. 79, 1980, STOKE-ON-TRENT, GB pages 139 - 145 T.I. BARRY ET AL 'The strength of experimental grinding wheel materials including use of novel glass and glass-ceramic bonds' * abstract; page 144, column 1, paragraph 1* -----		
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 13 OCTOBER 1992	Examiner RIBA VILANOVA
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ----- & : member of the same patent family, corresponding document	

EPO FORM 1503 01.92 (P0401)

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) Publication number:

0 495 536 A3

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: **92105935.8**

(51) Int. Cl.⁵: **B24D 3/14**, C09K 3/14,
B24D 3/16

(22) Date of filing: **01.08.85**

(30) Priority: **08.08.84 US 638917**

(43) Date of publication of application:
22.07.92 Bulletin 92/30

(60) Publication number of the earlier application in
accordance with Art.76 EPC: **0 171 034**

(84) Designated Contracting States:
AT BE DE FR GB IT SE

(98) Date of deferred publication of the search report:
09.12.92 Bulletin 92/50

(71) Applicant: **NORTON COMPANY**
1 New Bond Street
Worcester, MA 01606-2698(US)

(72) Inventor: **Rue, Charles Victor**
P.O. Box 206
Petersham, Massachusetts(US)

(74) Representative: **Diehl, Hermann Dr. et al**
Diehl & Glaeser, Hiltl & Partner
Flüggenstrasse 13
W-8000 München 19(DE)

(54) **Vitrified grinding wheel.**

(57) Bonding of sintered sol-gel aluminous abrasive grits, comprising sub-micron sized alpha alumina crystals, in vitrified (ceramic) wheels results in abrasive performance superior to premium grade fused alumina in grinding tool-steels. Viscosity of the bond and/or temperature of firing must be controlled to avoid reaction between the bond and the abrasive.

EP 0 495 536 A3

alkali to alumina to silica of 1 to 1 to 6, with 70% of the alkaline being potassium.

7. A process of making vitrified grinding wheels comprising polycrystalline aluminous abrasive grits in an inorganic glassy bond, characterized in that said grits are made of submicron alpha alumina particles having a non-cellular microstructure and having a density of at least 95% of theoretical, and in that the wheel is fired with the highest allowable temperature being about 1,100 °C and matured at a temperature of 1,100 °C, or below.
8. The process of claim 7 characterized in that said abrasive grits are prepared by firing dried alumina seeded gel particles.
9. The process of claims 7 or 8, characterized in that the firing of the grits is effected between 1,250 °C and 1,400 °C.
10. The process of claim 9, characterized in that the gel contains magnesia and/or zirconia.
11. The process of claims 7, 8, 9 and 10 in which the bond contains a molar ratio of alkali to alumina to silica of 1 to 1 to 6, with 70% of the alkaline being potassium.

(.47 Na₂O, 0.07 K₂O, 0.25 MgO, 0.21 CaO)
 0.58 Al₂O₃, 0.01 Fe₂O₃, 0.65 B₂O₃, 3.77 SiO₂, 0.03 TiO₂.

- 5 In grinding tests the following results were achieved for the 45% porosity (J8) wheels in grinding tool-steel employing 60 grit size (about 400 microns) abrasive.

	Infeed in Mils	J8			
		Dry Grind		Wet Grind	
		G	Power (Watts)	G	Power (Watts)
Fused (32A)	1/2	9.3	850	3.5	900
Sulfide process	1	15.9	1300	4.0	1350
abrasive	2	5.1	1700	2.2	1800
Sintered	1/2	22.6	950	2.7	1000
Alumina	1	32.3	1300	3.9	1400
Sol-gel	2	32.8	2200	3.5	1800
abrasive					

Similar wheels made from commercially available sol gel abrasives containing about 5% MgO were inferior to the fused alumina in both dry and wet grinding.

- 25 When fired at 1150°C., wheels containing the abrasive of this invention suffered a volume change (increase) of 7.9% and were inferior in grinding performance to the wheels containing the fused alumina (in which no volume change was observed in firing to 1150°C.). The commercial sol-gel abrasives suffered only about 2% linear growth on firing, but were still inferior to the fused abrasive wheels in grinding performance.

30 It is believed that the growth of the wheels on firing is caused by absorption of the glassy bond into the abrasive grits during firing. The submicron crystal size of the alumina in the grits, apparently being responsible for such attack by the bond, which attack occurs much less in the case of abrasive grits having larger crystal size. While with the conventional glass bond described above, the highest allowable temperature is about 1100°C., variation of the composition of the bond, to produce a more viscous material at the firing temperature, can permit the use of higher firing temperature.

- 35 For example, a glassy bond containing a molar ratio of alkali to alumina to silica of 1 to 1 to 6, with 70% of the alkali being potassium, could be fired to 1220°C. without damage to the abrasive.

Claims

- 40 1. A vitrified grinding wheel comprising aluminous abrasive grits and an inorganic glassy bond characterized in that said abrasive grits comprise sintered polycrystalline alumina grits made up of submicron alpha alumina particles having a non-cellular microstructure, said grits having a density of at least 95% of theoretical, the bond is a high alumina and silica bond and the wheel is fired at a temperature of 1220°C or less and matured at a temperature of 1220°C or below.
- 45 2. A vitrified grinding wheel as in claim 1, wherein said abrasive grits are prepared by firing dried alumina seeded gel particles.
- 50 3. The vitrified grinding wheel of claim 1, in which the gel contains 0.1 to 2.0 wt % of alpha alumina seed particles.
4. The vitrified grinding wheel of claim 3, in which the gel contains about 0.6 wt % of alpha alumina seed particles.
- 55 5. The vitrified grinding wheel of one of the preceding claims, in which the gel contains magnesia and/or zirconia.
6. The vitrified grinding wheel of one of the preceding claims in which the bond contains a molar ratio of

This invention relates to vitrified (glass) bonded grinding wheels containing aluminous abrasive.

Heretofore, the best abrasive (other than cubic boron nitride) for use in vitrified grinding wheels for grinding tool steels, e.g. toolroom grinding, have been very high purity alumina grits preferably produced by fusion of alumina in a sulfide matrix, and are essentially mono-crystalline particles.

Recently alumina-spinel abrasives produced by the process of U.S. Patent 4,314,827 have appeared on the market in coated abrasive products such as flexible cloth-bonded belts and fiber discs. Such abrasives, although they can be used in making conventional vitrified bonded grinding wheels, perform no better than the best alumina abrasive in dry grinding and are markedly less effective in wet grinding than the premium fused alumina abrasive.

It would be desirable to produce a vitrified grinding wheel containing an aluminous abrasive, made by sintering of an alumina gel, which is superior to the conventional fused alumina in vitrified grinding wheels.

We have discovered that, by the use of sintered alumina grits made up of submicron alpha-alumina particles having a non-cellular microstructure, vitrified bonded grinding wheels can be made which are markedly superior to such wheels which contain fused alumina as the abrasive.

Accordingly, the above object is met by a vitrified grinding wheel comprising aluminous abrasive grits and an inorganic glassy bond characterized in that said abrasive grits comprise sintered polycrystalline alumina grits made up of submicron alpha alumina particles having a non-cellular microstructure, said grits having a density of at least 95% of theoretical, the bond is a high alumina and silica bond and the wheel is fired at a temperature of 1220 °C or less and matured at a temperature of 1220 °C or below.

The abrasive employed in this invention differs from the commercially available sintered gel type abrasive in microstructure in that the commercial abrasives contain the alumina in the form of porous cells or grains having sometimes typically the appearance of sunbursts. The cells are generally coarser than 5 μm , typically 8 to 10 μm , and are single crystals. In the abrasive employed in this invention the cellular or sunburst structure is absent, and the alpha alumina particles are all submicron.

The abrasive useful in the present invention is made by firing at 1250 °C. to 1400 °C., dried alumina gel particles which contain submicron alpha-alumina seed particles in the amount, typically, of about 0.6% by weight. Such alumina gels need not, but may, contain magnesia and need not, but may, contain other additives such as zirconia.

First attempts to use abrasives in vitrified wheels resulted in total failure due to reaction between the bond and the abrasive. It was then discovered that if the firing temperature of the wheels was reduced to 1100 °C. or less, for conventional bonds, or 1220 °C. or less for more viscous high alumina and silica bonds, such adverse reaction was avoided. In other words the bond is matured at a temperature at which the integrity of the grits is not adversely affected by the bond. Such extreme sensitivity to firing temperature of the wheel is not found when the prior art sintered gel type alumina or fused alumina grits are employed.

Alumina grits were prepared by crushing and firing a dried gel containing sub-micron alpha alumina seed particles. The gel was produced by mixing alumina monohydrate powder (microcrystalline boehmite) with water, nitric acid, and about 1 weight % (0.1 to 2%) of submicron alpha alumina particles. After drying of the gel it was broken up and fired at 1350 °C. for about 5 minutes. Various examples of production of the abrasive can be found in co-pending Application Serial No. 85 100 506.6 filed Jan. 18, 1985, and in co-pending Application Serial Number 85 106 752.0 filed May 31, 1985.

Wheels were made from the non-cellular, at least 95% dense, abrasive made from seeded gels and compared to wheels made from premium commercially available fused alumina (sulfide process) and from abrasive grits corresponding to Example 41 (alumina and 5% magnesia) of U.S. Patent 4,314,827.

After mixing the abrasive grits with glass bond ingredients, grinding wheels were pressed to shape and to the desired porosity of 45% (the mix including 48 volume % abrasive and 7.1 volume %, as fired, of bond). The wheels were then fired to 1100 °C. at a rate of 60 °C. per hour, soaked at 1100 °C. for 6 hours and then the power was shut off and the wheels allowed to cool in the kiln to room temperature. The bond composition, on an oxide basis was 1 mole of alkali and alkaline earth oxides of composition A, below, and SiO_2 , TiO_2 and R_2O_3 oxides identified as composition B, below.

Composition A (mole fractions).

Na_2O , 0.47; K_2O , 0.07; MgO , 0.25; CaO , 0.21

Composition B (moles per mole of A)

Al_2O_3 , 0.58; Fe_2O_3 , 0.01; B_2O_3 , 0.65; SiO_2 , 3.77; Ti_2O_3 , 0.03.

The composition of the glass can thus be represented by the empirical formula:

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) Publication number:

0 495 536 A2

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: **92105935.8**

(51) Int. Cl.⁵: **B24D 3/14, C09K 3/14**

(22) Date of filing: **01.08.85**

This application was filed on 06 - 04 - 1992 as a divisional application to the application mentioned under INID code 60.

(30) Priority: **08.08.84 US 638917**

(43) Date of publication of application:
22.07.92 Bulletin 92/30

(60) Publication number of the earlier application in accordance with Art.76 EPC: **0 171 034**

(84) Designated Contracting States:
AT BE DE FR GB IT SE

(71) Applicant: **NORTON COMPANY**
1 New Bond Street
Worcester, MA 01606-2698(US)

(72) Inventor: **Rue, Charles Victor**
P.O. Box 206
Petersham, Massachusetts(US)

(74) Representative: **Diehl, Hermann, Dr.**
Dipl.-Phys. et al
Diehl, Glaeser, Hiltl & Partner
Flüggengstrasse 13
W-8000 München 19(DE)

(54) **Vitrified grinding wheel.**

(57) Bonding of sintered sol-gel aluminous abrasive grits, comprising sub-micron sized alpha alumina crystals, in vitrified (ceramic) wheels results in abrasive performance superior to premium grade fused alumina in grinding tool-steels. Viscosity of the bond and/or temperature of firing must be controlled to avoid reaction between the bond and the abrasive.

EP 0 495 536 A2